

Work Order ID 129381

129381

February-05-15 9:20:48 AM

Item ID: DSI 9685-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crossbolt Spacer Installation
 Start Date: 2/05/15 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 2/10/15 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9685	A

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC									
Doc.Control -USB or Paperwork									

Memo
 Photocopy bluefile & type labels per PPP DSI 9685-011 CHG001

110	Pick Kit	0.00							
110									
Packaging									
Packaging									

Memo

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC									
Quality Control									

Memo

(8x) DAS 46 FEB 10 2015 9-89
 8 FEB 10 2015 DAS 86 9-89
 DAS 28 9-89
 (8x) DAS 46 FEB 10 2015 9-89

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Item ID: DSI 9685-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crossbolt Spacer Installation

Start Date: 2/05/15

Start Qty: 8.00

8

Cust Item ID:

Required Date: 2/10/15

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9685-011
Location: F6123

(8x)

DAS
46
9-33

FEB 10 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5 15-02-11

ME

15-2-10

Picklist Print

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Work Order ID: 129381

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Parent Item: DSI 9685-011

DSI 9685-011

Parent Item Name: Crossbolt Spacer Installation

Start Date: 2/05/15

Required Date: 2/10/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 14.11.24 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5101-041		Manufactured	No				Each	77.0000	6	948			DAS 06 9-89
8 *D5101-041*	DAS 46 9-89								**				DAS 28 9-89
Crossbolt Spacer Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST227B				77					
				127966				17					
				128587				60					
D5101-3		Manufactured	No				Each	160.0000	12	96			DAS 06 9-89
8 *D5101-3*	DAS 46 9-89								**				DAS 28 9-89
Insert													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST147				160					
				127964				160					
D5101-5		Manufactured	No				Each	160.0000	12	96			DAS 06 9-89
8 *D5101-5*	DAS 46 9-89								**				DAS 28 9-89
Insert													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST147				160					
				127965				160					

FEB 06 2015
DAS
06
9-89
DAS
28
9-89

Picklist Print

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Work Order ID: 129381

Parent Item: DSI 9685-011

Parent Item Name: Crossbolt Spacer Installation

129381

DSI 9685-011

Start Date: 2/05/15

Required Date: 2/10/15

Start Qty: 8.00

Required Qty: 8.00

AN4C46A

Purchased

No

Each

232.0000

67 48

AN4C46A

Bolt

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**

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Location

Loc Qty

Loc Code

FG

2

123642

2

ST312A

170

m129431

100

m129505

70

ST341

60

m131367

60

Each

1,049.000

48

MS21043-4

Purchased

No

MS21043-4

Nut

DAS
46
9-89

**

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

490

m128798

490

ST304

519

m128798

485

m128818

34

Each

249.0000

192

NAS1149D0416J

Purchased

No

NAS1149D0416J

WASHER

DAS
46
9-89

**

Location

Loc Qty

Loc Code

GA

100

m131197

100

ST270

149

m125773

149

FEB 06 2015

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Shop Packet Print

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1
REF FAA STC: SR02024SE
REF EASA STC: 10040294

1.0 PURPOSE:

Customers may have experienced spinning inserts on Dart D119-646-013/-014/-113/-114/-213/-214 float skid tubes. This DSI provides a repair for those spinning inserts.

2.0 INSTALLATION:

- 2.1 Remove AN4C6A Bolts securing the 604.0902 Float to the RH skid tube
- 2.2 Remove the 12 inserts from the skidtube extension.
- 2.3 Open the insert holes (12x) to 0.437" +0.010/-0.000. Deburr and alodine hole per MIL-DTL-5541
- 2.4 Remove AN3 bolts securing the D2855-3 Cap to the skidtube. Break/remove sealant between cap and skidtube and remove cap. Clean off residual sealant and inspect for corrosion damage per Dart ICA-D119-646 Chapter 5.
- 2.5 Using locally procured 1/4-20 UNC threaded rod attached to the D5101-041 Crossbolt Spacer, slide it into the skidtube.
- 2.6 Align the holes in the D5101-041 Crossbolt Spacer with the newly drilled holes in the skidtube. Some adjustment of the size of the spacer is permitted to fit it to the deepest set of holes.
- 2.7 Using the D5101-3 and D5101-5 inserts, secure the D5101-041 Crossbolt Spacer to the skidtube. Reference Figure 1. Remove the threaded rod. Torque inserts to 95-110 in.lbs (10-12 N-m).
- 2.8 Repeat steps 2.4-2.7 for the other 2 crossbolt spacer locations.
- 2.9 Reinstall D2855-3 Cap with AN3 bolts. Seal bolts with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant. Torque bolts to 15-25 in-lbs (1.7-2.8 N-m). Apply a bead of Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 sealant between the cap and the skidtube.
- 2.10 Reinstall the 604.0902 Float onto the skidtube using 3x AN4C46A Bolts per Figure 1.
- 2.11 Repeat steps 2.1-2.10 for the LH skidtube.

3.0 PARTS LIST:

Qty. -011	PART NUMBER	DESCRIPTION
X	DSI 9685-011	CROSSBOLT SPACER KIT
6	D5101-041	CROSSBOLT SPACER ASSEMBLY
12	D5101-3	INSERT
12	D5101-5	INSERT
6	AN4C46A	BOLT
6	MS21043-4	NUT
24	NAS11490D0416J	WASHER

4.0 WEIGHT AND BALANCE

Incorporating this DSI causes the following weight and balance changes

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
DSI 9685-011 CROSSBOLT SPACER KIT	1.5 lb 0.68 kg	208.0 in 5.3 m	312 in-lb 3.6 kg-m	0.0 in 0.0 m	0.0 in-lb 0.0 kg-m

A	NEW ISSUE	AK	14.07.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	JL	DSI 9685	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSBOLT SPACER KIT	NTS
DATE	14.07.30	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	